



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200
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K642-511
Job Sheet 196297



Part No: K642-511

Job Qty: 2 pcs ✓

Part Name: Saddle 642-511

Master Unit N° 010618



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV Q SHEETS 33-34 IPP Rev:A 07.06.05 new issue EC IPP Rev.B 08.02.05 , Per ECN1080P LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		7/12/19	0.00	2.00	Packaging 1 - 1		
							Packaging 1 - 2		
							→ Packaging 1 - 3	<i>Wed 6-26-19</i>	<i>Oscar</i>
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S203676



Part: K642-511

Job No: 196297

Serial No/Batch: S203676

Revision:

Inspector:

Exp Date:

Instructions:

Date: 08/07/19

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					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					QC 4 - 28	
120 QC 4	2 pcs	7/12/19	0.00 0.00		QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS 75 9-89
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	08/10/2019
					QC 4 - 74	
130 Packaging 3-1 - Stock - B4B	2 pcs	7/12/19	0.00 2.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 75 9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	08/10/2019
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 9-89
135 DC - 1 - B4B	2 pcs	7/12/19	0.00 2.00		DC - 1 - B4B	AUG 12 2019
					DC - 2 - B4B	
140 QC 21 - FG	2 pcs	7/12/19	0.00 2.00		QC 21 - FG - 21	DAS 21 9-89
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 120 - (QC4- 100% Inspect kits for completeness)

Descriptions: 130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP K642-511

Location: _____

135 - (Document Control) Create White labels per PPP K642-511 CHG006

140 - (QC21- Final Inspection - Work Order Release)

Master Unit No: 010618

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C35A <i>ST347</i>	Bolt	6 Ea (3 ea) ✓	110-Packaging 1 - Pick Kit	<i>S075173</i> ✓
AN3C36A <i>ST347</i>	Bolt	18 Ea (9 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM137074-1ks</i> ✓ + <i>FM138002</i> ✓
AN3C41A <i>ST347</i>	Bolt	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM137074-2</i> ✓
AN4C6A <i>ST345</i>	Bolt	24 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	<i>S124255</i> ✓
AN5C11A <i>ST338</i>	Bolt	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	<i>S110001</i> ✓
AN5C12A <i>ST338</i>	Bolt	8 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM129245</i> ✓
AN5C13A <i>ST338</i>	Bolt	8 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM130466(ks)</i> ✓ + <i>S107797</i> ✓
AN5C15A <i>ST337</i>	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S099540</i> ✓
AN5C32A <i>ST336</i>	Bolt	4 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>S097244</i> ✓
AN5C34A <i>ST336</i>	Bolt	4 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM137279</i> ✓
AN5C35A <i>ST336</i>	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>FM129871</i> ✓
D206-648-013 <i>ST636</i>	Ground Handling Wheel Modification	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S188545(ks)</i> ✓ + <i>S194017</i> ✓
D2652 <i>ST009</i>	Bushing	32 pcs (16 ea) ✓	110-Packaging 1 - Pick Kit	<i>S148412</i> ✓
D2712 <i>ST010</i>	Set Screw	20 pcs (10 ea) ✓	110-Packaging 1 - Pick Kit	<i>S059857</i> ✓
D2932-1 <i>ST396</i>	Saddle LH Out, 206	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S165369</i> ✓
D2933-1 <i>ST396</i>	Saddle LH In, 206	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S163190</i> ✓
D2934 <i>ST014</i>	Saddle Spacer	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>S094244</i> ✓
D2935 <i>ST014</i>	Saddle Spacer	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>S101444</i> ✓
D2938-1 <i>ST395</i>	Saddle LH Out, 206	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S164415</i> ✓
D2939-1 <i>ST395</i>	Saddle LH In, 206	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S163206</i> ✓
D3396-3 <i>ST033</i>	Bushings	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>S153779</i> ✓
D3407-043 <i>ST530</i>	Tow Ring	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S177237(ks)</i> ✓ + <i>S057286(ks)</i> ✓
D3456-1 <i>ST036</i>	Washer	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S157300</i> ✓
D3457-1 <i>ST036</i>	Washer	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	<i>S172538</i> ✓
D3672-1 <i>ST047</i>	Washer, Phenolic	48 pcs (24 ea) ✓	110-Packaging 1 - Pick Kit	<i>S163255</i> ✓
D3672-3 <i>FP001</i>	Washer, Phenolic <i>ST047</i>	48 pcs (24 ea) ✓	110-Packaging 1 - Pick Kit	<i>S131565</i> ✓
D3672-7 <i>ST047</i>	Washer, Phenolic	48 pcs (24 ea) ✓	110-Packaging 1 - Pick Kit	<i>S131568</i> ✓
MS21043-3 <i>ST302</i>	Nut	40 Ea (20 ea) ✓	110-Packaging 1 - Pick Kit	<i>S181801</i> ✓
MS21043-4 <i>ST302</i>	Nut	26 Ea (13 ea) ✓	110-Packaging 1 - Pick Kit	<i>S144558</i> ✓
MS21043-5 <i>ST315</i>	Nut	8 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	<i>S156842</i> ✓
NAS1149C0332R <i>ST266</i>	Washer	48 Ea (24 ea) ✓	110-Packaging 1 - Pick Kit	<i>S174158</i> ✓
NAS1149C0432R <i>ST266</i>	Washer	48 Ea (24 ea) ✓	110-Packaging 1 - Pick Kit	<i>S155658</i> ✓
NAS1149C0532R <i>ST266</i>	Washer	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	<i>S106842</i> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C35A	6	41	0
	AN3C36A	18	263	0
	AN3C41A	16	357	0
	AN4C6A	24	546	0
	AN5C11A	16	90	0
	AN5C12A	8	56	0
	AN5C13A	8	45	0
	AN5C15A	2	31	0
	AN5C32A	4	31	0
	AN5C34A	4	105	0
	AN5C35A	2	50	0
	D206-648-013	2	2	0
	D2652	32	272	0
	D2712	20	509	0
	D2932-1	2	4	0
	D2933-1	2	4	0
	D2934	4	7	0
	D2935	4	12	0
	D2938-1	2	4	0
	D2939-1	2	3	0
	D3396-3	4	18	0
	D3407-043	2	8	0
	D3456-1	2	112	0
	D3457-1	4	33	0
	D3672-1	48	1,663	0
	D3672-3	48	10,784	0
	D3672-7	48	573	0
	MS21043-3	40	1,215	0
	MS21043-4	26	832	0
	MS21043-5	8	191	0
	NAS1149C0332R	48	2,746	0
	NAS1149C0432R	48	1,873	0
	NAS1149C0532R	16	204	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-557	WEARSHOE KIT (REPLACES -547 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D4956-15	* WEARSHOE ⁽¹⁾ (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	* WEARSHOE ⁽¹⁾ (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-39	* WEARSHOE ⁽¹⁾ (REPLACES D3535-39 + D3536-39)
25A					1	1				D4956-35	* WEARSHOE ⁽¹⁾ (REPLACES D3535-35 + D3536-35)
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: Q

Date: 13.08.12

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80								1	1	D4368-041	FWD WEARPLATE ASSY
81								1	1	D4368-043	AFT WEARPLATE ASSY
82A								1	1	D4383-1	WEARPAD
82B								1	1	D4383-3	WEARPAD
83								20	20	D3873-3	BUSHING
84									24	D3411-3	WASHER
85								2		D3275-1	SPACER
86A								6	6	AN3C40A	BOLT
86B								2	2	AN3C37A	BOLT
86C								2	2	AN3C36A	BOLT
87								10	10	MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: **Q**
 Date: 13.08.12